

Date: Thursday, 5/4/2006 11:19:17 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TUBE ASSEMBLY  
 Job Number : 26985  
 Estimate Number : 12183  
 P.O. Number : N/A Part Number : D3469043  
 This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D3469 REV A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A1  
 Previous Run : 26483 Material : N/A  
 Due Date : 5/28/2006 Qty: 8 Um: Each  
 Written By : See Comment Below  
 Checked & Approved By : 06/05/05  
 Comment : Est Rev: A New Issue 06-02-03 JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D34691

TUBE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3469-1 Tube B 27012

2.0

D34695

LOWER PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

LOWER PLATE

Batch: B 26114 -2

3.0

AN960C416L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C416L Washer M18822

4.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1


1-Assemble as per Dwg D3469 Using D18849 Assembly Jig, Use 1/4" Shaft To Align Butterfly Shaft holes

2-Spot Weld as per Dwg D3469 and Dart QSI 018

SB 06/06/08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/09

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/4/2006 11:19:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 26985

Part Number: D3469043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Bobek.08 (2)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/06/08 (2)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/09 (2)

Job Completion



li 860609

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

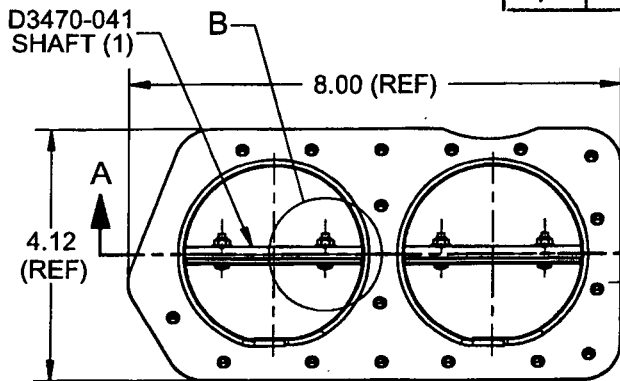
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED BOM ON PAGE 2	

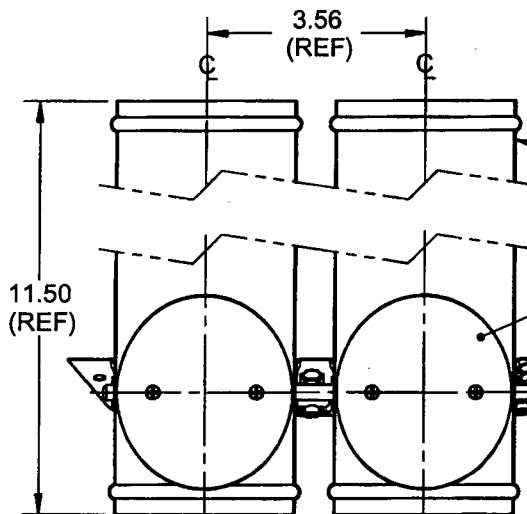
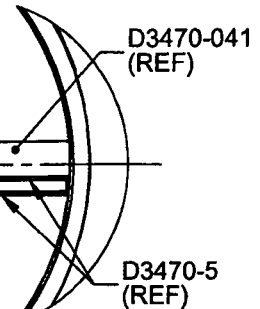


MS35206-217 SCREW  
AN960-4L WASHER  
NAS679-A04 NUT  
(4 PLACES)

D3470-7  
BUTTERFLY  
VALVE SEAL  
(2 PLACES)

MS24665-153  
COTTER PIN (1)

**DETAIL B**  
**SCALE 1:1**



**SECTION A-A**

D3469-043 TUBE  
ASSEMBLY (1)

D3470-5  
BUTTERFLY VALVE  
(4 PLACES)

D3470-9 BOLT (1)  
AN960-416 WASHER (4)  
AN310-4 NUT (1)

### D3469-041 SHUT-OFF VALVE ASS'Y

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

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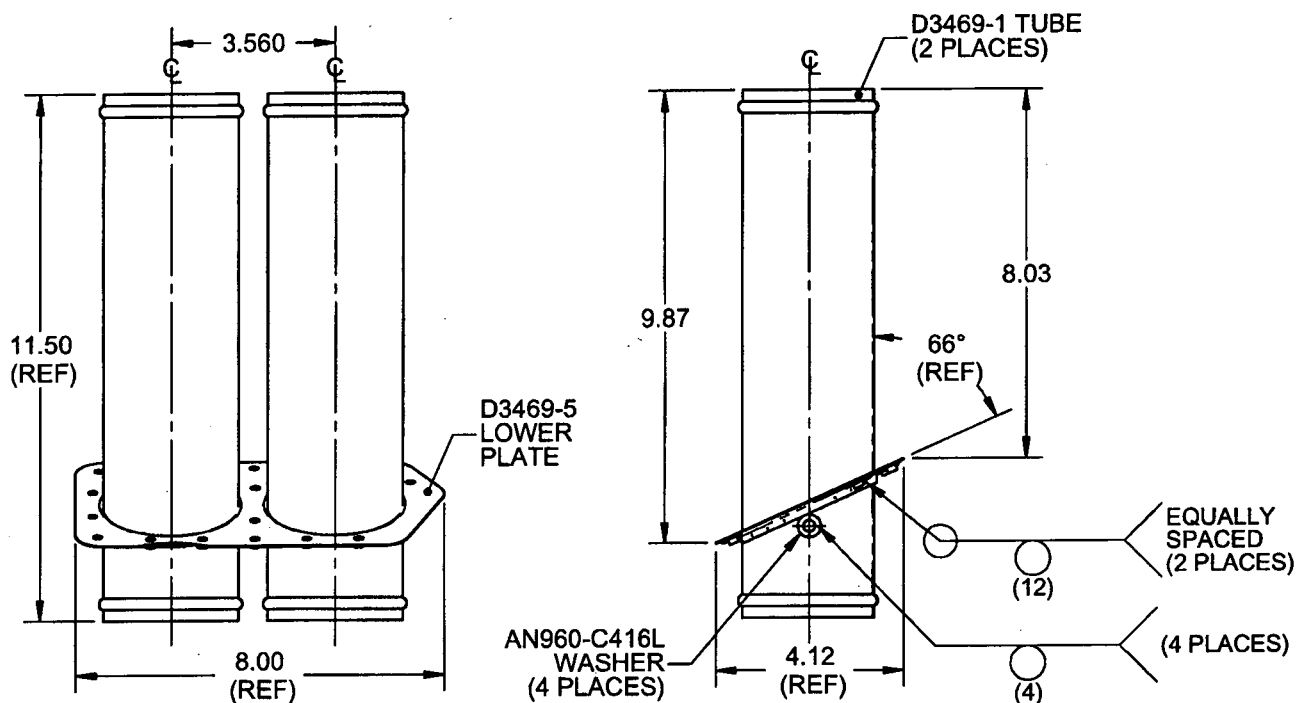
WORK ORDER

NO. 26985



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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

RELEASED  
# 06.04.03



### D3469-043 TUBE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3469-043	TUBE ASSEMBLY
2	D3469-1	TUBE
1	D3469-5	LOWER PLATE
<del>4</del>	<del>D3470-5</del>	<del>PLATE VALVE</del>
4	AN960-C416L	WASHER

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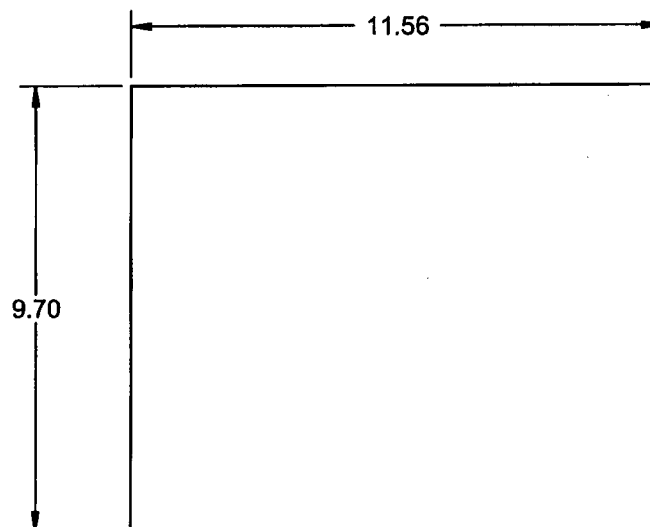
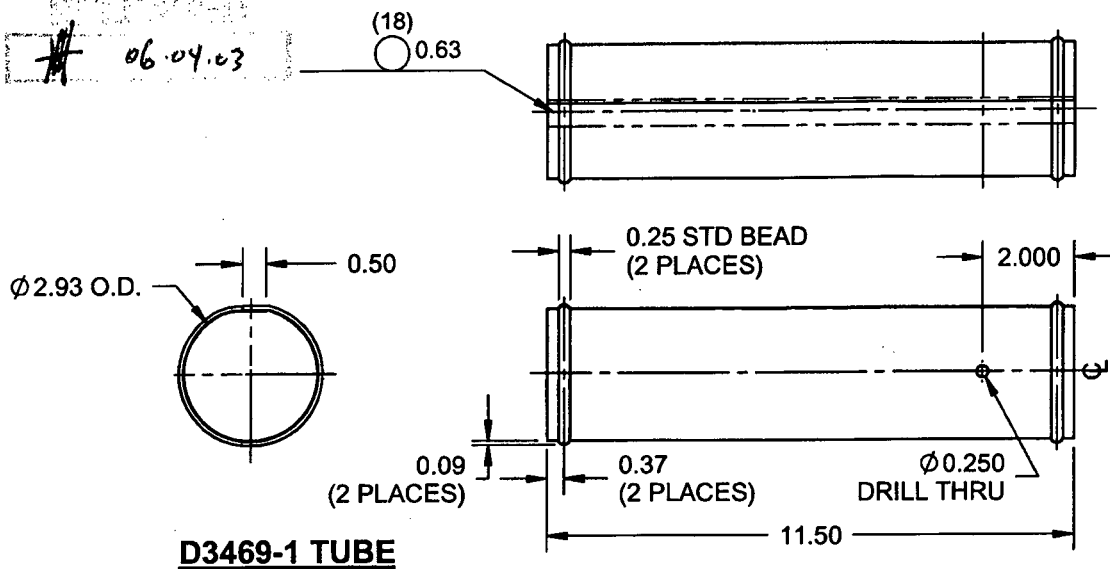
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4



### **D3469-1F TUBE FLAT PATTERN**

#### **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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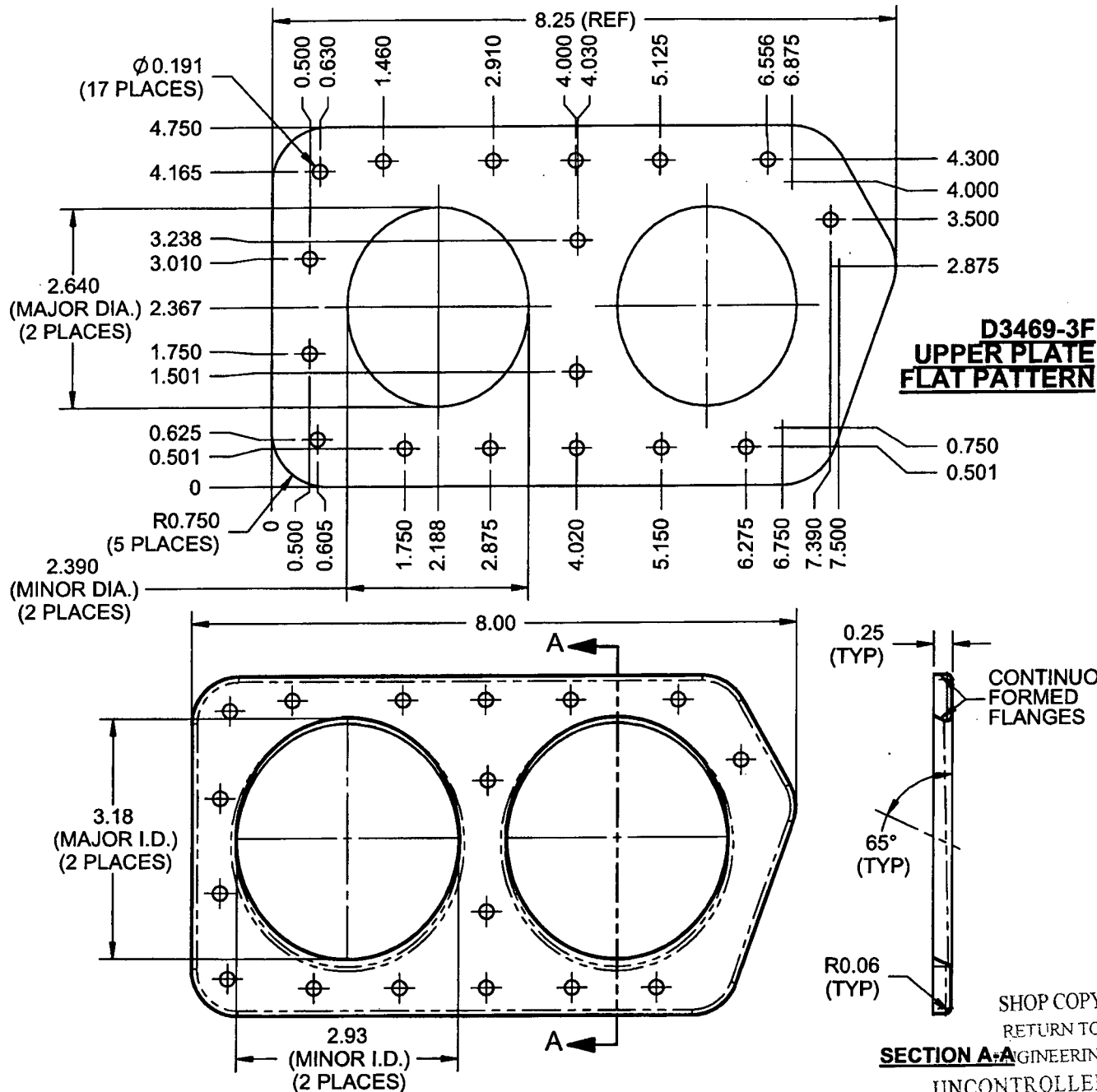
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DATE <b>05.12.12</b>	TITLE <b>SHUT-OFF VALVE ASS'Y</b>		SCALE 1:2

**D3469-3 UPPER PLATE BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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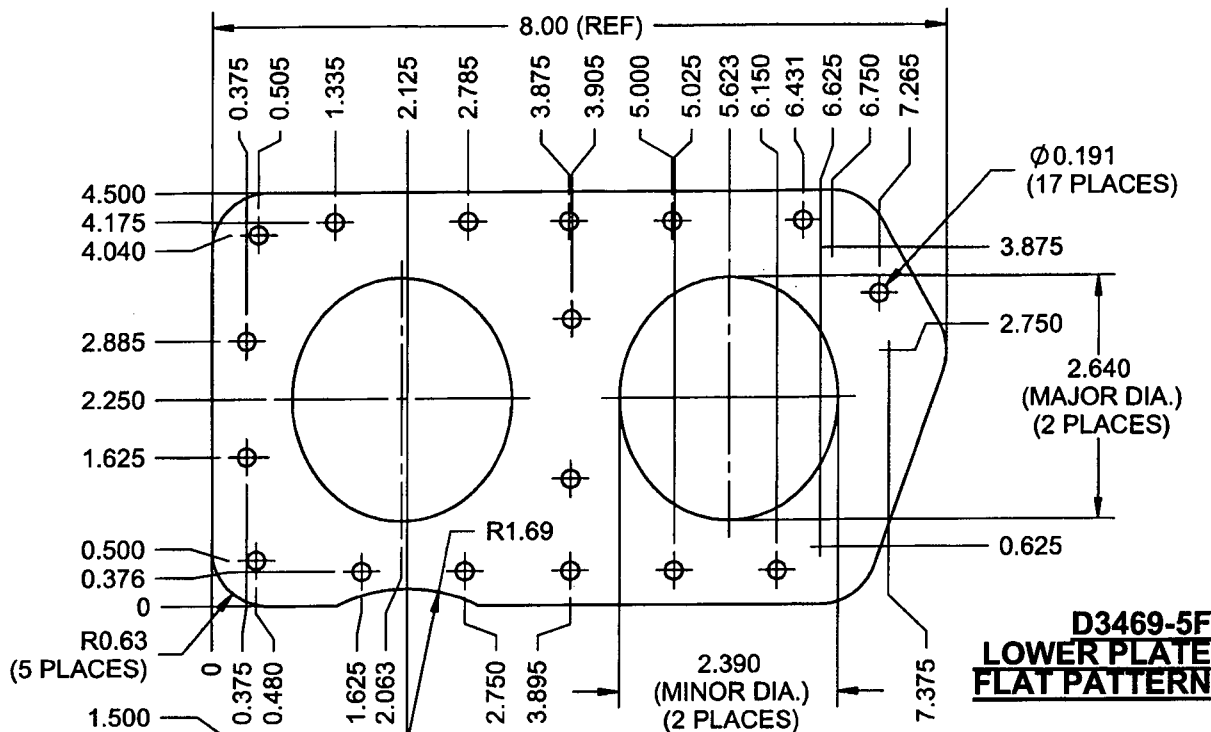
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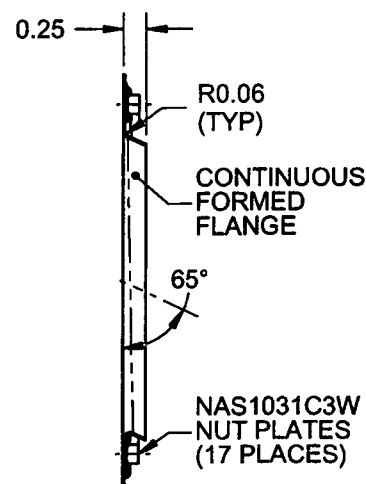
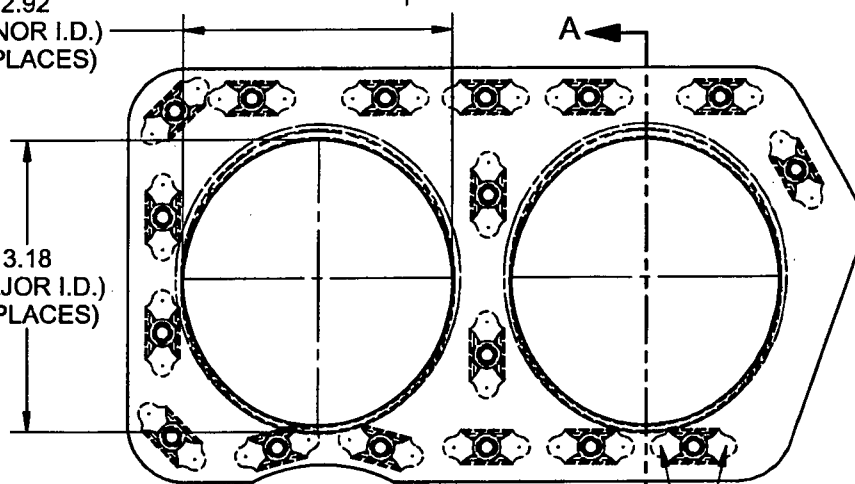


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DATE <b>05.12.12</b>		TITLE <b>SHUT-OFF VALVE ASS'Y</b>	SCALE 1:2



2.92  
(MINOR I.D.)  
(2 PLACES)

3.18  
(MAJOR I.D.)  
(2 PLACES)



### SECTION A-A

### D3469-5 LOWER PLATE

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) LED COPY
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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